

Work Order ID 80455

Tuesday, February 21, 2012 10:46:43 AM

80455

Page 1

Item ID: D3460-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearshoe

Start Date: 2/21/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***Approvals: Process Plan: *mc*

Date: 12-02-21 Tooling:

Date:

Stop ***NR2***

QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3460

Rev A

100

0.00

100

Waterjet

FLOW CNC Waterjet

1010 - 063

~~PURCHASING~~

Memo

1-Cut as per Dwg

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

A2577-101A

0.00

B12-2-21

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

B12-2-21

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

12 02 21 (43)

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Item ID: D3460-1

Revision ID:

Item Name: Wearshoe

Start Date: 2/21/2012 Start Qty: 4.00

Required Date: 2/24/2012 Req'd Qty: 4.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool # Plan

Code

Accept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Quality Control

Memo

0.00

Pl 12.02.23

4x

Ø

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

180

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:20
320°F
8:50

0.00

0.00

0.00

4X4 m/l 12/02/27

4 d m 12/02/27

190

QC3- Inspect Part Finish

190

QC

Quality Control

Memo

Picklist Print

Tuesday, February 21, 2012 10:46:42 AM

Page 1

Work Order ID: 80455

Parent Item: D3460-1

Parent Item Name: Wearshoe

Start Date: 2/21/2012

Required Date: 2/24/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.02.21 as per dwg rev.A DD Ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA 1010/1025 sheet 16GA		Purchased	No			100	sf	76.0000	0.775	3.2631579			

12-2-21

Location

Loc Qty

Loc Code

MAT019

76

116791

21.4

117500

24.6

118965

30

117500

(4)

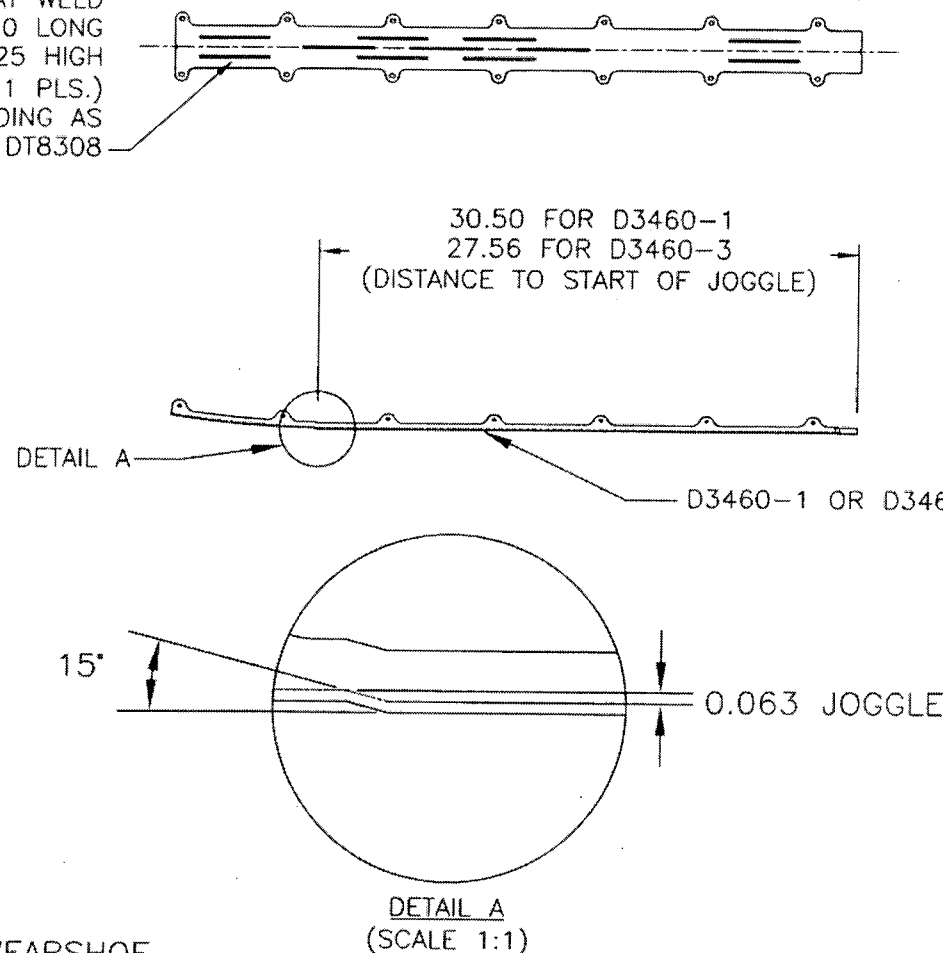


RELEASED
8.11.14

#80055

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
PH	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
PH	PH	D3460	SHEET 1 OF 1
DATE		TITLE	SCALE
05.10.04		WEARSHOE	1:10
A	05.10.04	NEW ISSUE	

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

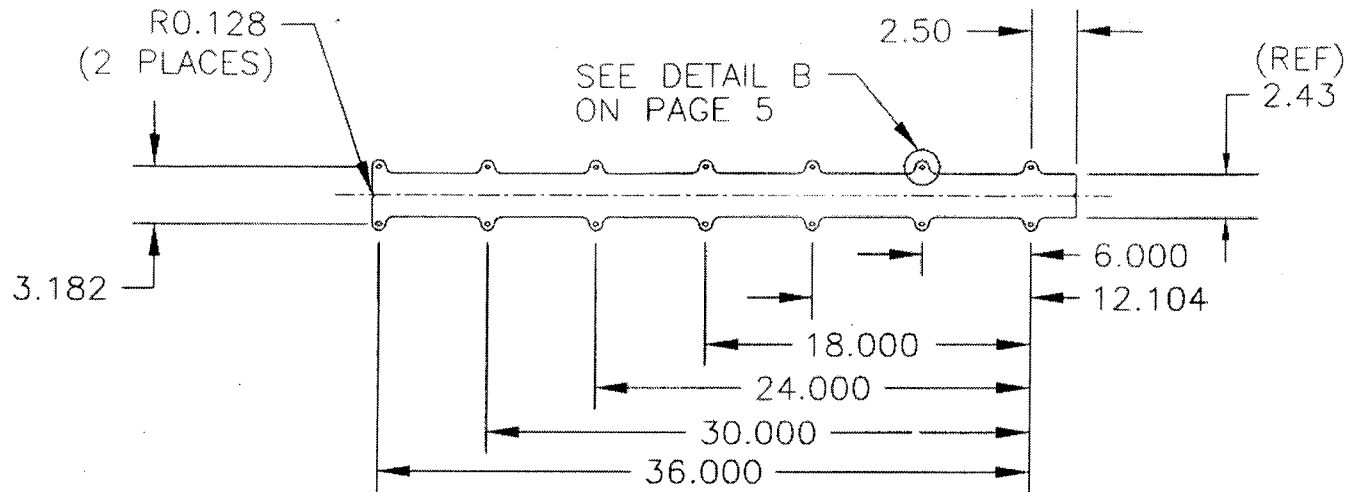


D3460-1/-3 WEARSHOE

- 1) MAKE D3460-1 FROM D2577-11 LONGITUDINAL BEND
- 2) MAKE D3460-3 FROM D2577-13 LONGITUDINAL BEND
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2577
DATE 00.09.22		TITLE WEARSHOE
		REV. E SHEET 2 OF 5
		SCALE 1:10



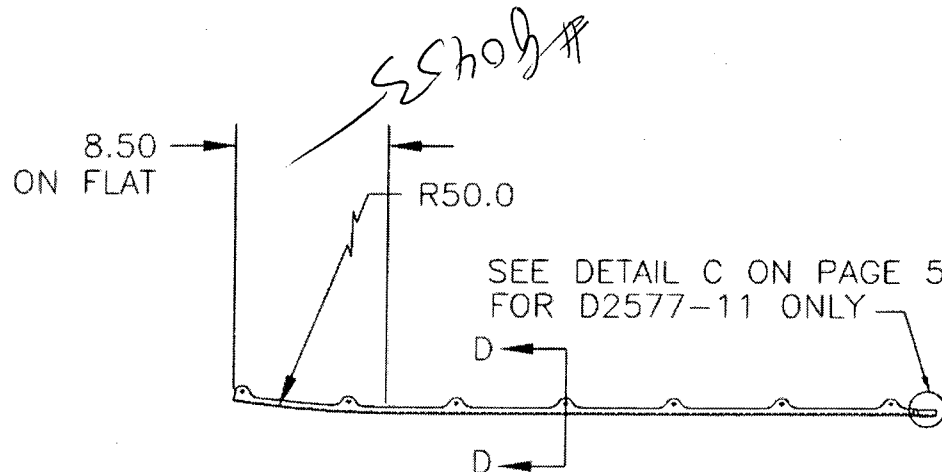
D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

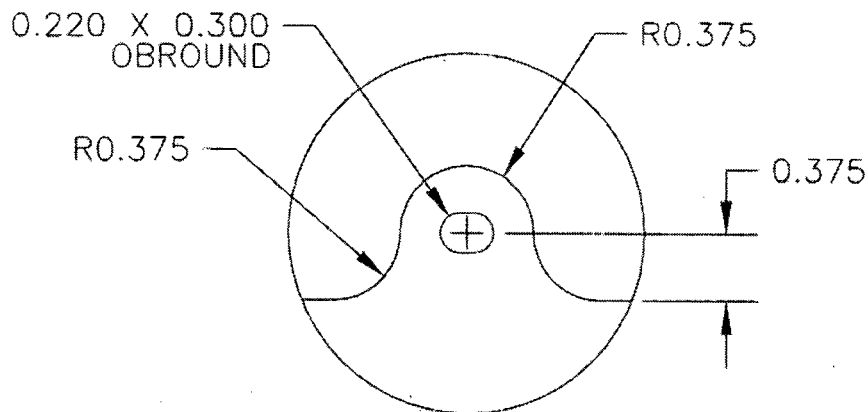
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00.09.26

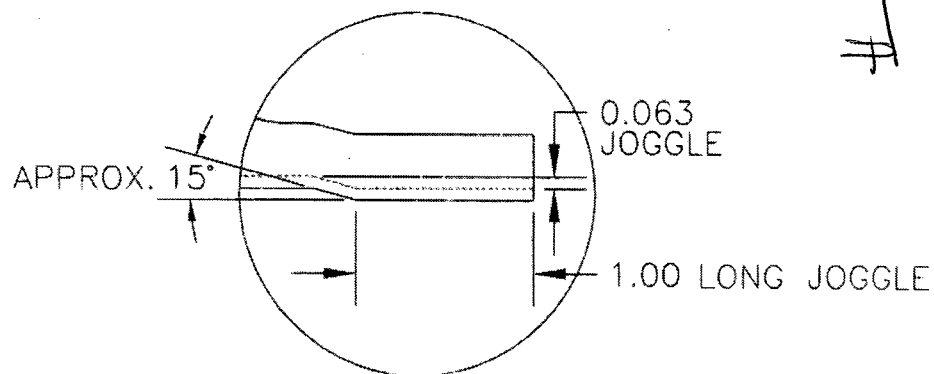


DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

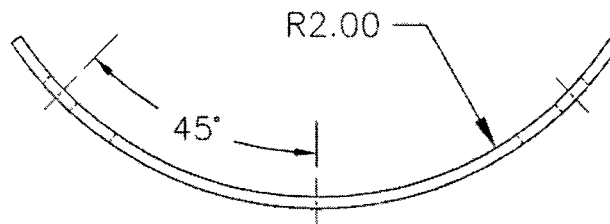
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



RELEASED
00.09.22

#80455

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